



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3847-043
Job Sheet 166394



Part No: D3847-043

Job Qty: 1 ea

Part Name: Wearplate Fwd



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/1/17

Job Tracking No:

Due Date: 10/31/17

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV D SHEETS 3,7 IPP RevA: New issue DD verified by:EC IPP REV:B 14.11.25 AS PER DWG REV.C DD VERF:JLM IPP REV:C 16.03.31 AS PER DWG REV.D DD VERF:JLM

Ship Via:

Bill of Materials

Part/Part Name	Part Note	Serial No	Quantity	Location
D3847-043	DWG REV D SHEETS 3,7 IPP RevA: New issue DD verified by:EC IPP REV:B 14.11.25		0.000	
Wearplate Fwd	AS PER DWG REV.C DD VERF:JLM IPP REV:C 16.03.31 AS PER DWG REV.D DD VERF:JLM			
M304S18GA			0.000	
304/316 .050				
Sheet				

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea	10/30/17	0.00	0.00	Start up container	DAS
170	HandFinish	1 pcs	10/31/17	0.00	0.20	HandFinish4	41 OCT 31 2017
180	QC	1 pcs	10/31/17	0.00	0.00	QC3	9-89 38
190	Packaging	1 pcs	10/31/17	0.00	0.00	Packaging3	9-89
200	QC21-SA	1 Ea	10/31/17	0.00	0.00	QC21	

Part Op 170 - APPLY TEXTURE COATING ON TOP CONCAVE SURFACE AS PER DWG TEXTURE COATING
Descriptions: BATCH: 138351
190 - LOCATION : FG002

DAS 21
9-89 NOV 07 2017

Job BOM

Part / Item	Component Name	Quantity	Operation	Special Comments
D3847-043 B166394		1.0800 Ea (1.08 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D3847-043 B166394	1	10	0	0

Part Specification

Specifications could not be found

Status: Stock

Part: **D3847-043 B166394**

Created: 9/30/17 1:00 PM DART.MICHAUD-
FEBRILLE.VICTORIA



Serial No: S000196

Printed By: Goldston, Justin 10/2/17 10:45 AM

DART
AEROSPACE
S004413

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Wearplate Fwd

PART NO: D3847 – 043

Revision:

Operation: HandFinish

Quantity: 10

Change No:

Mfg Date: 10/31/17

Job No: 166394

Work Order Summary

Thursday, September 28, 2017 8:14:06 AM

Page 1 of 1

Criteria : Work Order ID: 166394 Item ID: D3847-043 Product Family LARGE FAB
Work Order Start Dates 9/19/2017 to 9/19/2017 11:59:59 PM Work Order Required Dates 9/22/2017 to 9/22/2017 11:59:59 PM
All References
Work Order Status Released

Work Order ID 166394 Required Qty 10.0000 Status Code Released
Item ID D3847-043 Accepted Qty 0.0000 Scrap Qty 0.0000
Item Name Wearplate Fwd
Current Acct Value \$43.745

Start Date 9/19/2017 Required Date 9/22/2017 Completed Date

Standard	** Actual **		** Acct. Value **	** Variance **	** Variance % **
Direct Costs	Total	Each	Each	Each	Each
Material	\$49.582	\$0.000	\$4.697	\$4.697	100.00%
Labor	\$42.891	\$0.000	\$10.967	\$10.967	100.00%
Outplant	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Fixed Burden	\$107.824	\$0.000	\$28.081	\$28.081	100.00%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
** Total **	\$200.296	\$0.000	\$43.745	\$43.745	

Item ID/Item Name	Required Qty	Issue Code	Issue Date	Issued Qty	Cost Amount
M304S18GA 304/316 .050 Sheet	11.3684		9/21/2017	12.0000	\$49.582
Total Matl Amts:					\$49.582

Work Center Brake NC

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
BOUC01												
9/25/2017												
130			0.25	0.25	0.25	0.25	1.00	\$5.375	\$5.375	\$21.820	\$0.000	\$32.570
Total:			0.25	0.25	0.25	0.25	1.00	\$5.375	\$5.375	\$21.820	\$0.000	\$32.570

Work Center Waterjet

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
CARR02												
9/21/2017												
100			0.00	0.00	1.56	1.56	1.00	\$0.000	\$32.141	\$86.004	\$0.000	\$118.145
Total:			0.00	0.00	1.56	1.56	1.00	\$0.000	\$32.141	\$86.004	\$0.000	\$118.145

Work Order ID 166394

Tuesday, September 19, 2017 3:26:16 PM

166394

Page 1

Item ID: D3847-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate Fwd
Start Date: 9/19/2017 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 9/22/2017 Req'd Qty: 10.00 ***10*** Customer:
Reference: SEP 19 2017
Approvals: Process Plan: Wey Date: SEP 19 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3847	D								
100		0.00							
100									
Waterjet	Memo	1.75							
FLOW CNC Waterjet	1-Cut D3847-3 as per Dwg								
	Dwg Rev: <u>3</u>								
	Prog Rev: <u>8</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.10							
Quality Control									

⑩ 17/09/22 DAS 40 9-89
⑩ 17/09/22 DAS 40 9-89

Tuesday, September 19, 2017 3:26:16 PM

Item ID: D3847-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Wearplate Fwd

Stop ***NS2***

Start Date: 9/19/2017 **Start Qty:** 10.00

10

Cust Item ID:

Required Date: 9/22/2017 **Req'd Qty:** 10.00

10

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
Qty

Reject Number

**Insp.
Stamp**

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

1.00

Quality Control

Picklist Print

Tuesday, September 19, 2017 3:26:16 PM

Page 1

Work Order ID: 166394

166394

Parent Item: D3847-043

D3847-043

Parent Item Name: Wearplate Fwd

Start Date: 9/19/2017

Required Date: 9/22/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP RevA: New issue DD verified by:EC
14.11.25 AS PER DWG REV.C DD VERF:JLM IPP REV:C 16.03.31
AS PER DWG REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S18GA

Purchased

No

100

sf

139.0199

1.08

11.36842

M304S18GA

17/09/22

DAS
40
9-89

304/316 .050 Sheet

Location

Loc Qty

Loc Code

MAT020

138.2159

M135779

7.02

M136036

4.65

M136568

12.6959

M136687

2.24

M136790

2.54

M137481

12.8

M137980

16.77

M138346

15.5

M138486

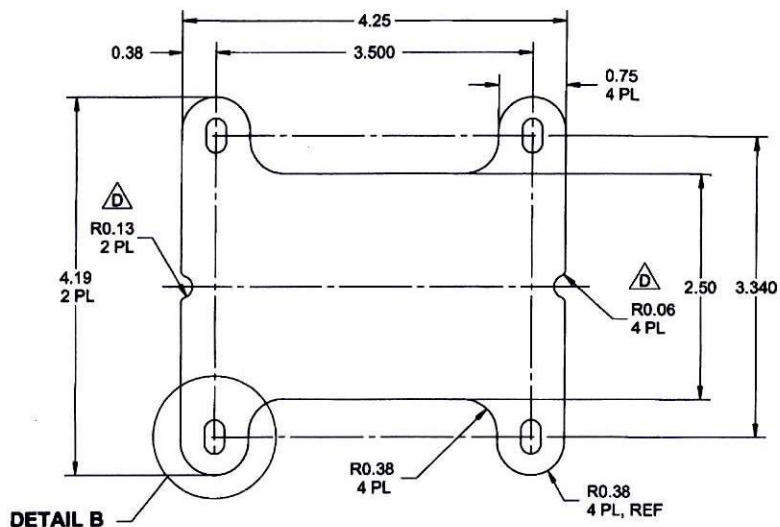
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MAT20

0.804

M134580

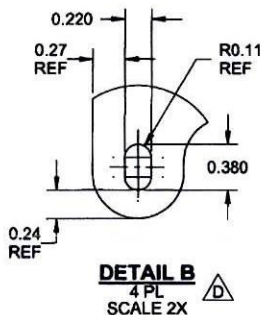
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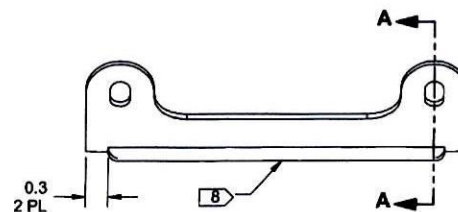
D3847-1F WEARPAD
(FLAT PATTERN)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 166394

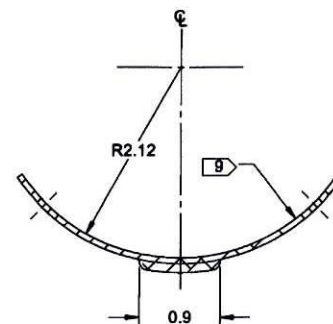
SEP 19 2017



DETAIL B
4 PL
SCALE 2X



D3847-1 WEARPAD
(MAKE FROM D3847-1F)



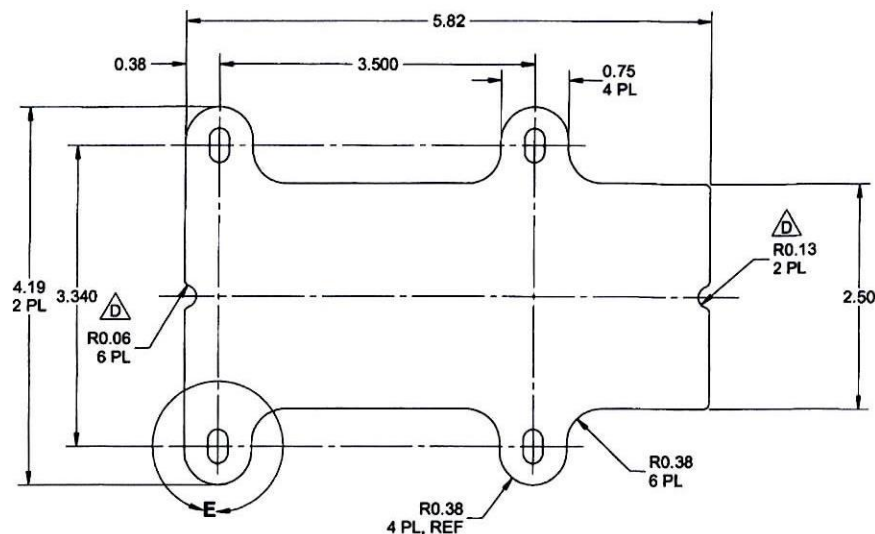
SECTION A-A

D	UPDATE NOTES FOR AUTOMATED WELDING. UPDATE CURRENT DRAWING STANDARDS AND TOLERANCES. REMOVE FINISH. ADD TEXTURED COATING NOTE. UPDATE MATERIAL NOTES. -3F, -5F, -7F & -9F SIDE VIEW REMOVED. 3B7, 7B2, 7B1 REMOVED 0.080 DIMENSION. D81, D61, 8C7, 8C5, R0.13 TOOLING NOTCHES ADDED. ACCORDINGLY 8C2, 0.2 DIM WAS 0.05 (MANUFACTURING REQUEST).	AJS	15.09.28
C	REMOVED D3846-3/5/7/9 GASKETS. ZN D2-1. ADDED TEXTURED COATING, ZN B3-1. UPDATED WEIGHTS, ZN C3-1/A8-2	AK	14.08.06
B	CORRECT TYPO D3847-047 WAS D3847-045. ZN B5-1; 5.82 WAS 8.25 (ZN A4-2); 45.28 WAS 45.71 (ZN B4-5)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	AJS		
CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	DD	D3847	SHEET 1 OF 7
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
DATE	15.09.28	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

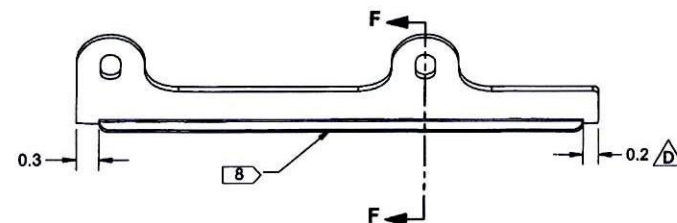
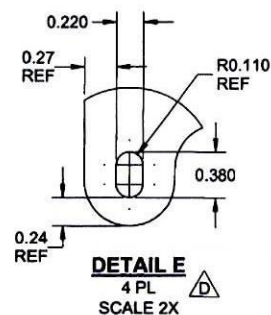
- NOTES:**
- 1) MATERIAL -1F: AISI 304/316 STAINLESS STEEL 16 GAUGE 0.063 THICK PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 REF DART SPEC. M304S16GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.23 lbs
 - 8) BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR BUILDUP HARD SURFACING 0.19 TO 0.25 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
 - 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.02-0.04 THICK, PER DART QSI 005 4.9

RELEASED
2016-03-31
EN 16-554

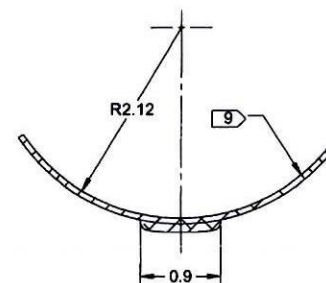
APPROVED



D3847-11F WEARPAD
(FLAT PATTERN)



D3847-11 WEARPAD
(MAKE FROM D3847-11F)



SECTION F-F

- NOTES:**
- 1) MATERIAL -11F: AISI 304/316 STAINLESS STEEL 16 GAUGE 0.063 THICK
PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S16GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.43 lbs
 - 8) BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR
BUILDUP HARD SURFACING 0.19 TO 0.25 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
 - 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.02-0.04 THICK, PER DART QSI 005 4.9

RELEASED
2016-03-31

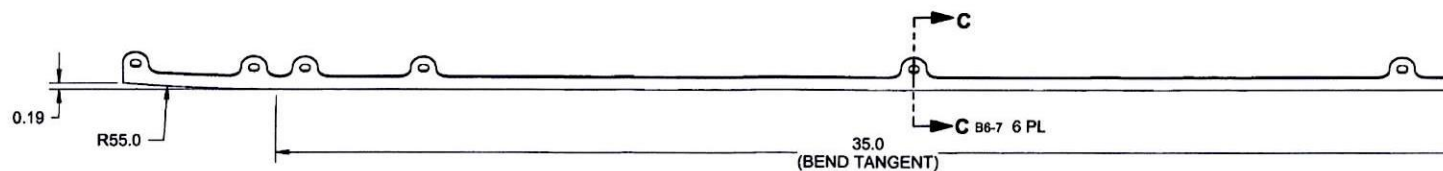
APPROVED

DESIGN	RF	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	AJS		
CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	DD	D3847	SHEET 2 OF 7
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DE APPR.	DS	WEARPLATE ASSY	NTS
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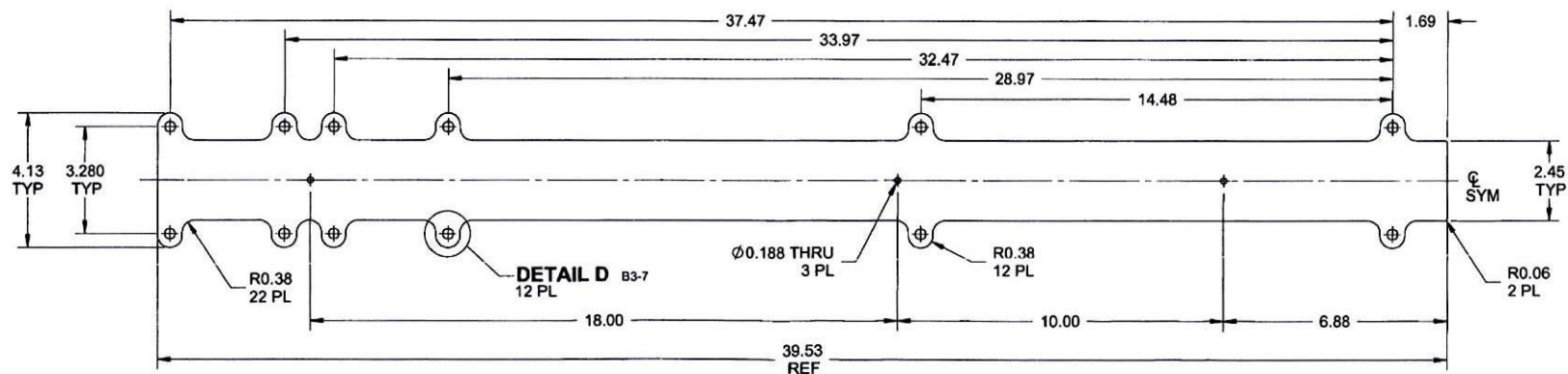
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	X	D3847-043	FWD WEARPLATE ASSY
1	1	D3847-3	PLATE



D3847-043 FWD WEARPLATE ASSY



D3847-3 PLATE
(MAKE FROM D3847-3F)



D3847-3F PLATE
(FLAT PATTERN)

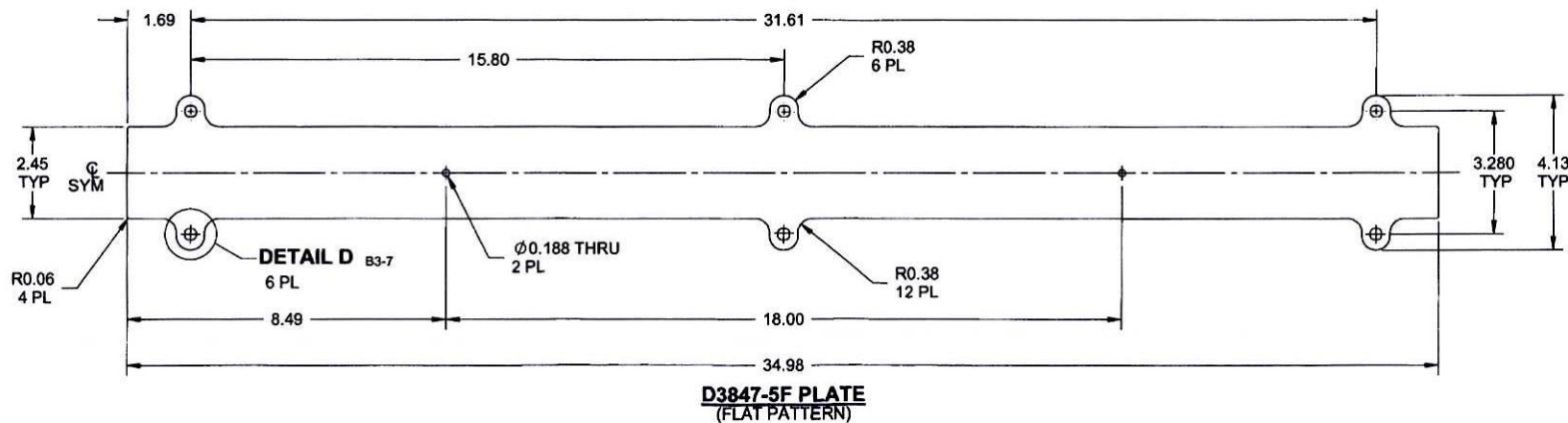
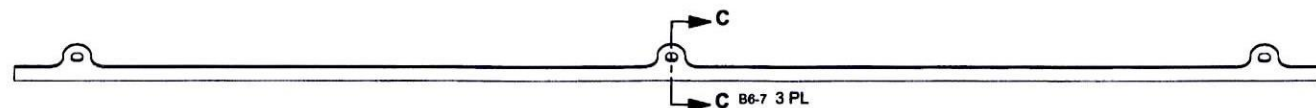
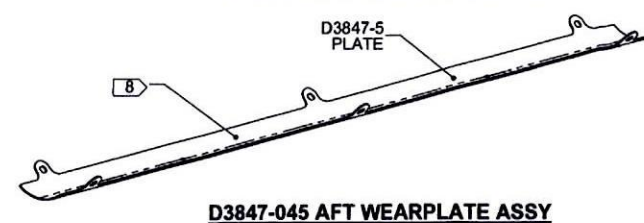
- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 18 GAUGE 0.050 THICK
PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 1.48 lbs
 - 8) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.02-0.04 THICK, PER DART QSI 005 4.9

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2016-03-31

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DESIGN	RF	DART AEROSPACE USA, INC. EUGENE, OR	
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CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	DD	D3847	SHEET 3 OF 7
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DE APPR.	DS	WEARPLATE ASSY	NTS
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ITEM	QTY -045	P/N	DESCRIPTION
	X	D3847-045	AFT WEARPLATE ASSY
1	1	D3847-5	PLATE



NOTES:

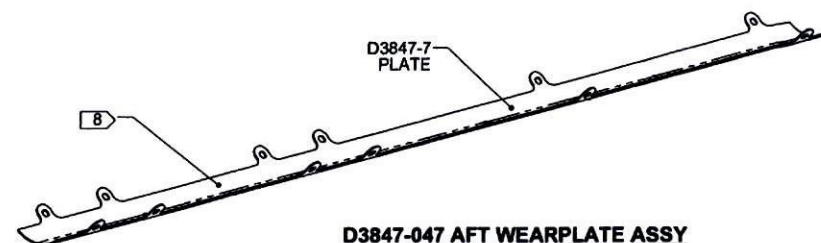
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 18 GAUGE 0.050 THICK
PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.29 lbs
- 8) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.02-0.04 THICK, PER DART QSI 005 4.9

RELEASED
2016-03-31

APPROVED

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	AJS	EUGENE, OR	
CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	DD	D3847	SHEET 4 OF 7
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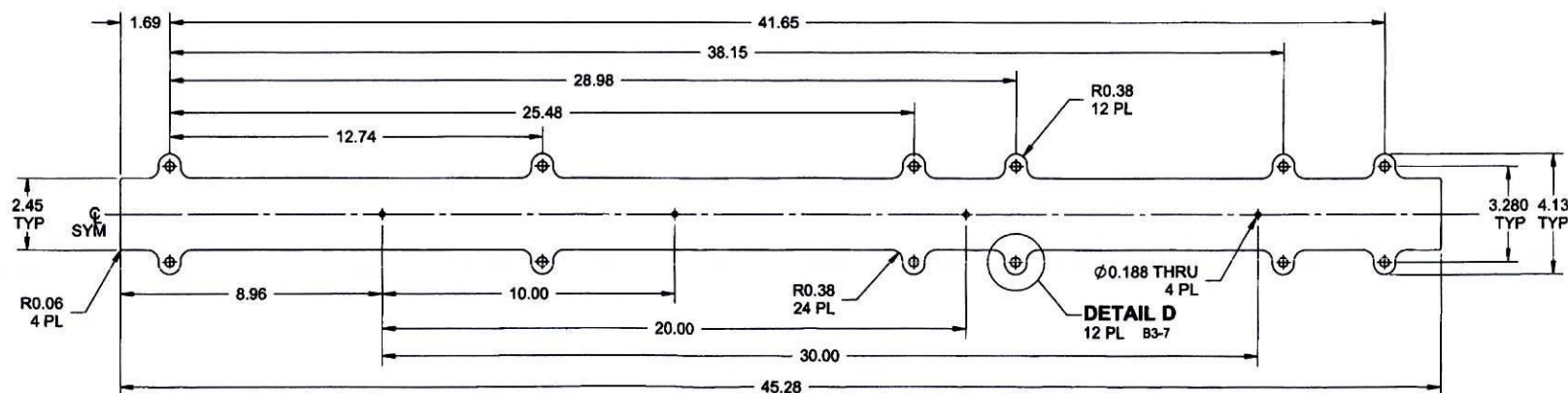
ITEM	QTY	P/N	DESCRIPTION
	X	D3847-047	AFT WEARPLATE ASSY
1	1	D3847-7	PLATE



D3847-047 AFT WEARPLATE ASSY



D3847-7 PLATE
(MAKE FROM D3847-7F)



D3847-7F PLATE
(FLAT PATTERN)

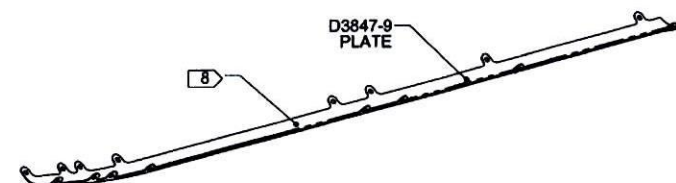
- NOTES:**
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PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 1.70 lbs
 - 8) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.02-0.04 THICK, PER DART QSI 005 4.9

RELEASED
2016-03-31

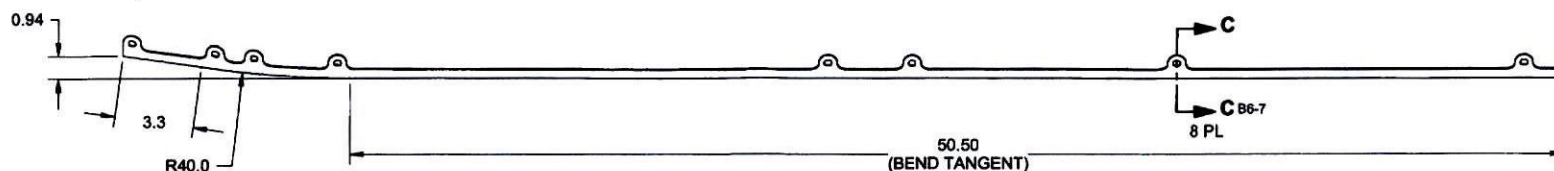
APPROVED

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	AJS	EUGENE, OR	
CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	DD	D3847	SHEET 5 OF 7
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
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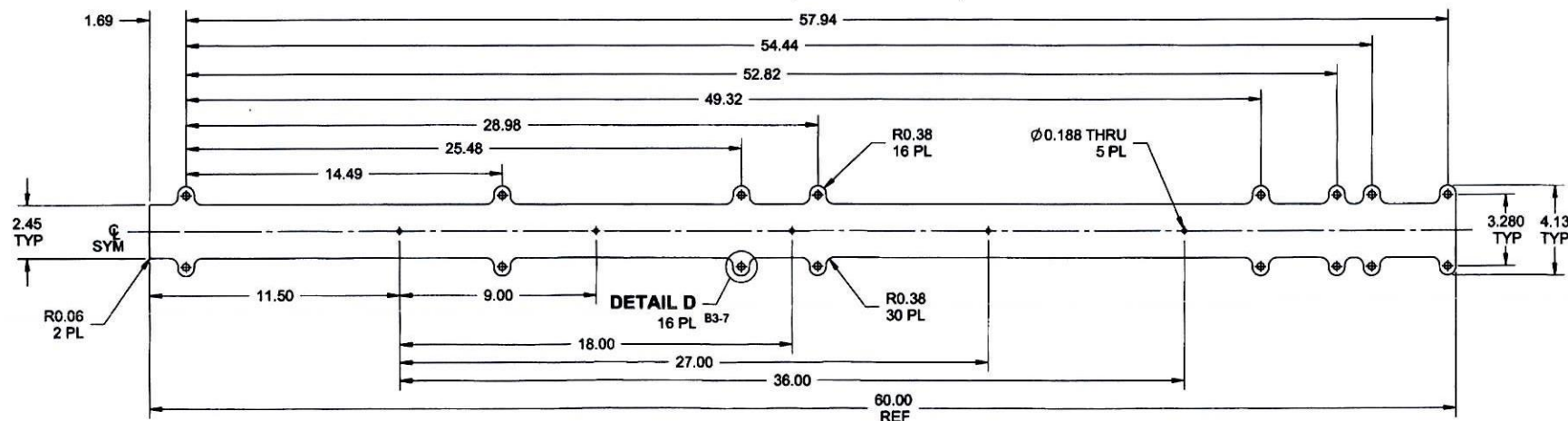
ITEM	QTY	P/N	DESCRIPTION
	X	D3847-049	WEARPLATE ASSY
1	1	D3847-9	WEARPLATE



D3847-049 AFT WEARPLATE ASSY



D3847-9 PLATE
(MAKE FROM D3847-9F)



D3847-9F PLATE
(FLAT PATTERN)

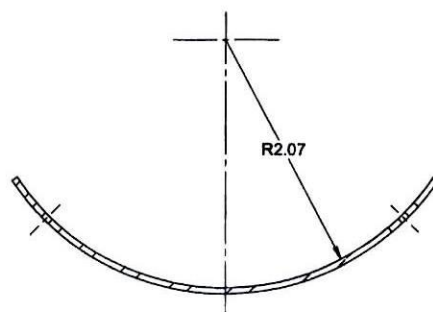
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- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 18 GAUGE 0.050 THICK
PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 3.86 lbs
- 8) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.02-0.04 THICK, PER DART QSI 005 4.9

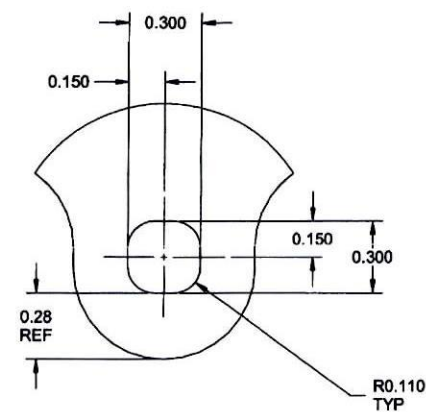
RELEASED
2016-03-31

APPROVED

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	AJS	EUGENE, OR	
CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	DD	D3847	SHEET 6 OF 7
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
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SECTION C-C
SCALE 4X
C3-2
C4-3
C3-4
C2-5



DETAIL D
SCALE 4X
B5-2
B6-3
B3-4
B4-5

RELEASED
2016-03-31

APPROVED

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	AJS	EUGENE, OR	
CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	DD	D3847	SHEET 7 OF 7
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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : 17/11/2		Step #:		QTY Effective :			MRB (QSI042) Approval DAS 12 9-89 17/11/2		
Description Work Order Deviation				Disposition				Completed By	
Axalta adhesion promoter not required. Eng testing indicated no benefit to it's use. Use of Axalta add's significant production time.				Acceptable to omit Axalta adhesion promoter.					
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY		
Environment	☐	No Re-verification	☐	Pressure/Forced	☐
Design	☐	Operator	☐	Bending	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐
Material	☐	Use for Testing	☐	Cuffs	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐
Past Expiry Date	☐	Manufacturing Process	☐		
Misidentified	☐	Past Due	☐	OTHER :	